

Work Order ID 81753

Friday, March 16, 2012 3:38:08 PM

81753

April 4th

Page 1

Item ID: D4030-041 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Basket Assembly (350)
 Start Date: 3/19/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/6/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *mf* Date: *12-03-16* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4030	C								

100 Pick Kit 0.00

100

Packaging Memo 0.00
 Packaging

JB

12/04/04

110 Assemble as per dwg 0.00

110

HandFinish Memo 0.00

Hand Finishing ****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label ****

1

BLD-4-4

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC Memo 0.00

Quality Control

Sirley

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81753

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81753

Page 2

Item ID: D4030-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Long Basket Assembly (350)
Start Date: 3/19/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/6/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging	<i>PM 81753</i>								<i>Run 4/9</i>
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							<i>12/4/5</i>
Quality Control									<i>inf</i> <i>12-04-04</i>

W/O:		WORK ORDER CHANGES					
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Picklist Print

Friday, March 16, 2012 3:38:07 PM

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Work Order ID: 81753

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 3/19/2012

Required Date: 4/6/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-210 200 Placard, Max Load <i>per NCR 12-12-39</i>		Manufactured	No				Each	5.0000		<u>69500</u>			JB
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST122		4							
				66275		1							
				76298		3							
				ST124		1							
				64869		1							
D2530 Handle Weldment		Manufactured	No			100	Each	8.0000	1	1			JB
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST506		8							
				77030		2							
				78965		6				<u>78965</u>			
D2535 Spring		Manufactured	No			100	Each	42.0000	2	2			JB
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		42							
				77488		42				<u>77488</u>			
D2537 Bushing		Manufactured	No			100	Each	32.0000	2	2			JB 12/04/04
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		32							
				77055		32				<u>77055</u>			
D3913-041 Long Basket Base Assembly, 350		Manufactured	No			100	Each	0.0000	1	1			BL 12-24-11
D3914-041 Long Basket Lid Assembly (350)		Manufactured	No			100	Each	0.0000	1	1			BL 12-4-11

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Page 2

Work Order ID: 81753

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 3/19/2012

Required Date: 4/6/2012

Start Qty: 1.00

Required Qty: 1.00

D3917-3	Manufactured	No	100	Each	115.0000	6	6	✓ JB
Washer								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST070	115				
			76956	4				
			80598	9				
			81205	102		81205		
D3953-3	Manufactured	No	100	Each	24.0000	2	2	✓ JB
Gas Spring Stud, Lid								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST075	24				
			76659	4				
			78042	20		78042		
D3953-7	Manufactured	No	100	Each	12.0000	2	2	✓ JB
Spring Spacer								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST075	12				
			76295	12		82645		
D3953-9	Manufactured	No	100	Each	16.0000	2	2	✓ JB
Gas Spring Washer								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST075	16				
			78916	16		78916		
D3953-17	Manufactured	No	100	Each	5.0000	2	2	✓ JB
Gas Spring Spacer								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST075	5				
			76294	5		81454		
D3953-19	Manufactured	No	100	Each	13.0000	1	1	✓ JB 12/04/04
Gas Spring Bracket								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST075	13				
			75227	13		75227		

Friday, March 16, 2012 3:38:07 PM

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Page 2

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Friday, March 16, 2012 3:38:07 PM

Page 3

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Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 3/19/2012

Required Date: 4/6/2012

Start Qty: 1.00

Required Qty: 1.00

D3953-21	Manufactured	No	100	Each	0.0000
Gas Spring Bracket					
D3969-3	Manufactured	No	100	Each	14.0000
Spring (Basket Lid)					

1 81207 ✓ JB
1 81887 ✓ JB

Location	Loc Qty	Loc Code
ST272	14	
64285	1	
73515	13	

AN3-14A	Purchased	No	100	Each	92.0000
Bolt					

4 4 ✓ JB

Location	Loc Qty	Loc Code
ST352	92	
119328	92	

AN3-16A	Purchased	No	100	Each	135.0000
Bolt					

2 2 ✓ JB
119328

Location	Loc Qty	Loc Code
ST352	135	
117441	49	
118628	36	
120986	50	

AN5-17A	Purchased	No	100	Each	80.0000
Bolt					

4 4 ✓ JB

Location	Loc Qty	Loc Code
ST338	80	
117872	42	
120498	38	

AN4-12	Purchased	No	100	Each	86.0000
Bolt					

3 3 ✓ JB 12/04/04
120498

Location	Loc Qty	Loc Code
ST357	86	
118626	11	
119775	25	
120986	50	

120986

Friday, March 16, 2012 3:38:07 PM

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Page 3

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Friday, March 16, 2012 3:38:07 PM

Page 4

Work Order ID: 81753

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 3/19/2012

Required Date: 4/6/2012

Start Qty: 1.00

Required Qty: 1.00

AN310-4	Purchased	No	100	Each	72.0000	3	3	✓ JB
NUT								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST344	72	
120124	22	
120518	25	
121011	25	

120124

AN310C4	Purchased	No	100	Each	46.0000	2	2	✓ JB
Nut								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST344	46	
119324	16	
120360	30	

121162

MS21042L3	Purchased	No	100	Each	3,041.0000	6	6	✓ JB
Nut								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	3041	
117441	16	
117885	32	
118451	5	
118927	3	
119017	2812	
119075	173	

119017

MS21042L5	Purchased	No	100	Each	1,598.0000	4	4	✓ JB 12/04/04
Nut								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	1598	
116105	5	
116548	43	
117611	42	
118179	8	
119109	1500	

119109

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Friday, March 16, 2012 3:38:07 PM

Page 5

Work Order ID: 81753

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 3/19/2012

Required Date: 4/6/2012

Start Qty: 1.00

Required Qty: 1.00

MS24665-151 Cotter Pin	Purchased	No	100	Each	311.0000	3	3	✓ JB
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST309	311				
			17566	311		17566		
MS24665-300 Cotter Pin	Purchased	No	100	Each	208.0000	2	2	✓ JB
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			GA	200				
			118234	200		118234		
			ST309	8				
			116823	8				
NAS1149F0432P Washer	Purchased	No	100	Each	322.0000	6	6	✓ JB
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST275	322				
			120360	122				
			121060	200		4x 121060		
NAS1149F0563P Washer	Purchased	No	100	Each	89.0000	4	4	✓ JP
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST275	89				
			117735	89		117735		
NAS1149F0332P WASHER	Purchased	No	100	Each	654.0000	8	8	✓ JB 12/04/04
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST275	654		121166		
			117735	37				
			119225	14				
			120498	200				
			120910	200				
			120986	200				
			17317	3				

Friday, March 16, 2012 3:38:07 PM

Shop Packet Print

Page 5

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

Friday, March 16, 2012 3:38:07 PM

Page 6

Work Order ID: 81753

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 3/19/2012

Required Date: 4/6/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased

No

100

Each

2,526.0000

2

2

Washer

✓ 2.0 12/04/04

Location

Loc Qty

Loc Code

ST297

2526

117291

1526

119124

1000

117291

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

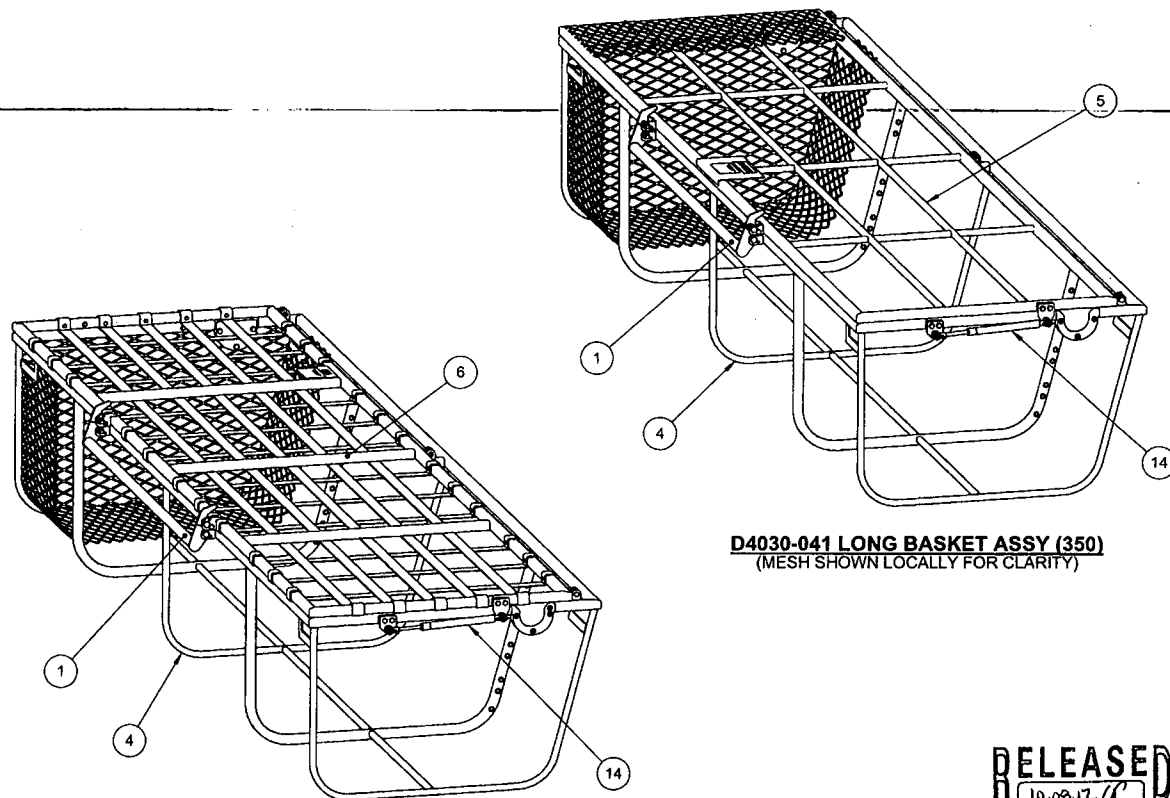
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NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10-08-12
ECN 10-596

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (BB-1); QTY FOR ITEM #3 WAS 4 (DB-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3)	MB	10.07.23
B	AN5-21A BOLT WAS AN5-18A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV.
MFG. APPR.	JFS	D4030	SHEET 1 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	#	LONG BASKET.ASSY (350) _____ NTS	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
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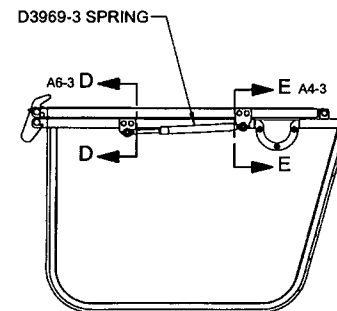
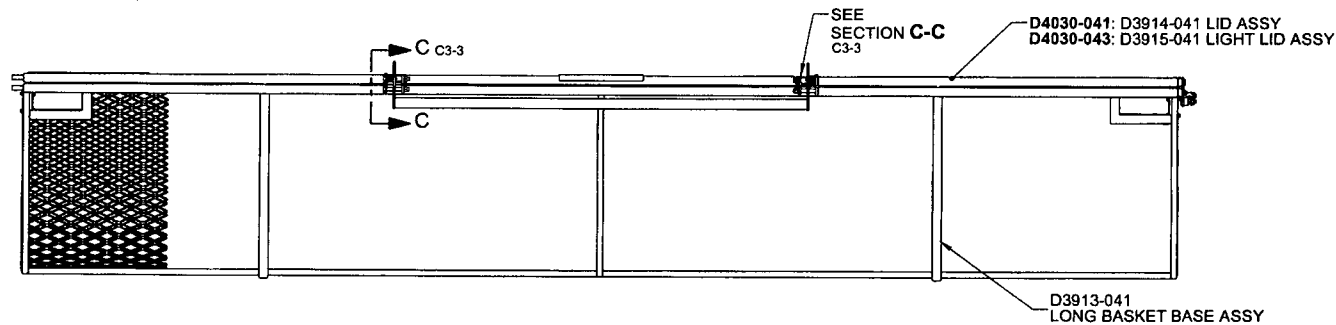
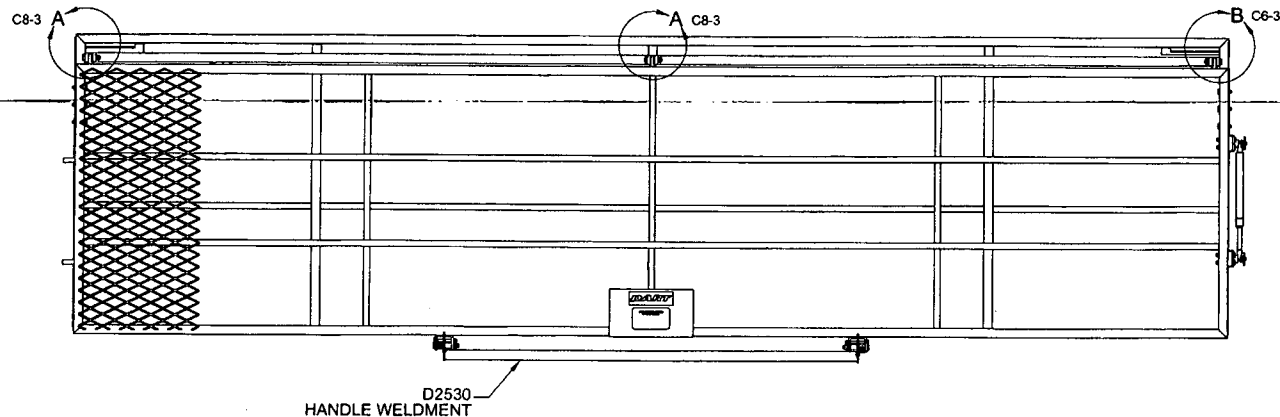
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8 7 6 5 4 3 2 1



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP	DRAWING NO.	REV. C
CHECKED	JP	D4030	SHEET 2 OF 3
MFG. APPR.	SES	TITLE	SCALE
APPROVED	JP	LONG BASKET ASSY (350)	NTS
DE APPR.	JP	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.07.23		

8 7 6 5 4 3 2 1

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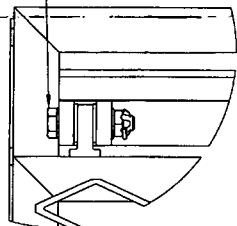
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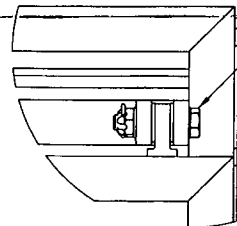
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AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



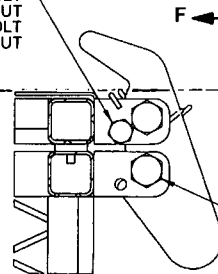
DETAIL A D8-2
D5-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL B D3-2

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT

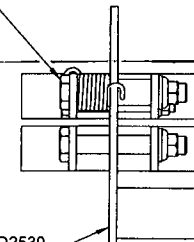


SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT



D2530
HANDLE WELDMENT
REF

VIEW F-F C3-3

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

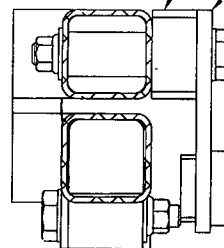
D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL



D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
10.08.124

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	5	HAWKESBURY, ONTARIO, CANADA	
CHECKED	2	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4030	SHEET 3 OF 3
APPROVED	JFS	TITLE	SCALE
DE APPR.	JFS	LONG BASKET-ASSY (350) — NTS	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries